

Work Order ID 164638

Wednesday, July 26, 2017 2:40:03 PM

Sold Alone

164638

Ship Aug 23

Page 1

Item ID: D3391-025

Accept



N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Tube Assembly

Start Date: 8/10/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/22/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: **DAS 21**

Date: JUL 26 2017 Tooling:

Date:

Stop *NR2*

QC: **9-89**

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3391	J
-------	---

100

0.11

100

Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

Turn as per Folio FA599

Rev: *AA* & Dwg D3391 Rev: *J*

1.30

ensure steady rest is turning true

****REMOVE STEADY REST AND MACHINIG MARKS****

1 0 PMP 01-08-2017

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.02

1 0 PMP 01-08-2017

DAS 23 9-89

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Page 2

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 8/10/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/22/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
112 *112* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				<u>1</u>			DAS 33 9-89 AUG 09 2017
120 *120* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA 599 Rev: <u>44</u> & Dwg D3391 Rev: <u>✓</u> 2-Deburr	0.32 1.74				<u>1</u>	<u>8</u>		DAS 33 9-89 17/08/16
130 *130* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.01				<u>1</u>	<u>8</u>		DAS 33 9-89 17/08/16

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 8/10/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/22/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							
140									
QC	<i>★</i> Memo	0.02				<u>1</u>	<u>0</u>		DAS 45 9-89 2017-8-16
Quality Control	<i>SEE Attached</i> ***INSPECT INSIDE BORE***								
150	Skidtubes	0.00							
150									
Skidtubes	Memo	0.33							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								<i>JW</i> <u>17.08.18</u>
160	BENDING MACHINE - SKIDTUBES	0.31							
160									
CNC Bend 1	Memo	0.53							
CNC Delta 100 Bender	Form as per Dwg D3391 Using Bend Prog 3391025								<i>JW</i> <u>17.08.18</u>

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 8/10/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/22/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.02							
Quality Control									

Handwritten notes: 4.3" (next to 0.00), 1 (under Accept Qty), 0 (under Reject Qty), 17-08-18 (under Reject Number), BK (over Insp. Stamp)

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Item ID: D3391-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Tube Assembly

Start Date: 8/10/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/22/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.02

Quality Control

POSITIVE RECALL**EFFECTIVE** 17/8/17 **AUTH** qp**RELEASED** qp **DATE** 17/8/21Test fit girt.1

AUG 21 2017

200

Chemical Conversion Coat per QSI005 4.1

0.00

200

HandFinish

Memo

0.84

Hand Finishing

(1)

2017-08-21

MAC JSC

210

QC7-Inspect Chemical Conversion Coat

0.00

210

QC

Memo

0.02

Quality Control

117-08-21

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 8/10/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/22/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
220	Skidtubes					1	0	2017/08/23	AP
Skidtubes	Memo	0.67							
Skidtubes	1- Install nutplate using MS20601AD4W ³ (qty12) in the six most forward holes and MS20601AD4W ³ (qty8) in the four aft holes. Rivet nutplates as per section TT on sheet 11.								
	2- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: M136671 exp. date: 17-11-01 cure time 12hrs as per QSI0015	16:00							
	3- Grind crossbolts flush								
	4- Back drill using #9 drill								
	5- Touchup Magnabond								
	6- Deburr								
230	QC5- Inspect part completeness to step on W/O	0.00							
230	Memo	0.02							
QC									
Quality Control									

POSITIVE RECALL

EFFECTIVE 17/8/21 AUTH CP

RELEASED CP DATE 17/8/21

Test fit OK

DAG
38
9-89
AUG 25 2017

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 8/10/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/22/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
235	Pressure Wash per QSI005 4.3	0.00							
235	HandFinish	0.34				(X1)			201708/28
Hand Finishing	Memo AND REALODINE AS PER PAR09-043								BEB.
240		0.00							
240	SprayPaint	0.00							
Spray Painting	Memo PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____								
	PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT: _____								
246	Inspecting - Review + Inspect								
250	QC14/Inspect Spray Paint	0.00							
250	QC	0.02							
Quality Control	Memo								

DAS
13
9-89

AUG 29 2017

1 x 8P17 8-30

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Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Tube Assembly
Start Date: 8/10/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/22/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	HandFinishing	0.00							
260	HandFinish	Memo							
Hand Finishing	1- Install inserts as per Dwg D3391	0.68							
	2- Install Aft Cap as per Dwg D3391								
	A/ R Sikaflex-241/-291 <u>M137946</u>								
	Sikaflex expiry date: <u>18103</u>								
	3- INSTALL WEARPLATES AS PER DWG								
270	QC5- Inspect part completeness to step on W/O	0.00							
270	QC	Memo							
Quality Control		0.20							
280	Identify as per dwg & Stock Location: <u>wlo</u>	0.00							
280	Packaging	Memo							
Packaging		0.50							

0412-742-043/B161822

1x of all 17109/06

1x of all 17109/06

DAS 9 9-89

Picklist Print

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Page 1

Work Order ID: 164638

164638

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 8/10/2017

Required Date: 8/22/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4095-047		Manufactured	No			260	Each	15.0000	1	1			
D4095-047													
Wearpad Aft													

Location	Loc Qty	Loc Code
FP001	15	
154327	5	
162009	10	

D4095-049		Manufactured	No			260	Each	18.0000	1	1			
D4095-049													
Wearpad Aft													

Location	Loc Qty	Loc Code
FP001	18	
150415	2	
158172	4	
161988	12	

13164733

XL

Picklist Print

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Page 2

Work Order ID: 164638

164638

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 8/10/2017

Required Date: 8/22/2017

Start Qty: 1.00

Required Qty: 1.00

MS20601-AD4W3

Purchased

No

260

Each

409.0000

12

12

MS20601-AD4W3

Rivet

B138238

**

JW 17-08-23

Location

Loc Qty

Loc Code

CCK004

100

m137963

100

LG001

199

m137459

3

m137820

196

ST308

110

m137587

110

MS20601-AD4W7

Purchased

No

260

Each

450.0000

8

8

MS20601-AD4W7

RIVET

AA

**

JW 17-08-23

Location

Loc Qty

Loc Code

LG001

450

m135839

6

m137148

444

MS21075L5

Purchased

No

260

Each

939.0000

10

10

MS21075L5

Nut Plate

**

JW 17-08-23

Location

Loc Qty

Loc Code

GA

939

m137405

7

m137951

482

m138041

200

m138042

250

Picklist Print

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Work Order ID: 164638

164638

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 8/10/2017

Required Date: 8/22/2017

Start Qty: 1.00

Required Qty: 1.00

D6014-090 Manufactured No

100 Each 19.0000 1 1

D6014-090

Aluminum Extrusion

**

LocationLoc QtyLoc Code

LG003

19

139426

19

D3670-4-200 Manufactured No

230 Each 93.0000 4 4

D3670-4-200

Bushing

**

LocationLoc QtyLoc Code

FG

10

87709

10

LG001

83

138819

3

158305

32

159315

48

D2646 Manufactured No

270 Each 10.0000 1 1

D2646

Aft Cap

**

LocationLoc QtyLoc Code

FG

2

90495

2

FP001

8

136885

3

149748

1

159719

4

31-07-2017 PMP

17-08-21

D.P.

4

1709106

X1

B161506

Picklist Print

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Work Order ID: 164638

164638

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 8/10/2017

Required Date: 8/22/2017

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

850.0000

2

2

D3672-1

Washer, Phenolic

**

ell 12/09/06

Location

Loc Qty

Loc Code

FG

10

85222

10

FP001

340

150074

340

ST047

500

163255

500

X2

ALS4-1032-130

AELS4-1032-130

Purchased

No

260

Each

5,778.000

8

8

ALS4-1032-130

Rivnut

**

ell 12/09/06

Location

Loc Qty

Loc Code

FG

100

FG

M135442

50

M136579

50

FP001

5617

M133077

3

M136579

614

M137820

5000

st555

61

M136579

61

X8

Picklist Print

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Work Order ID: 164638

164638

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 8/10/2017

Required Date: 8/22/2017

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

AELS8-1032-225

Purchased

No

270

Each

2,380.000

4

4

AI S4-1032-225

**

all 12/09/08

Rivnut

Location

Loc Qty

Loc Code

FG	55	
M134975	20	
M135998	5	
M136579	30	
FP001	2014	
M135603	40	
M135920	38	
<u>M135998</u>	1925	<i>x4</i>
M136265	11	
ST556	311	
M136579	311	

Picklist Print

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Work Order ID: 164638

164638

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 8/10/2017

Required Date: 8/22/2017

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

1,141.000

6

6

AN3C4A

all 12/10/10 6

Bolt

Location

Loc Qty

Loc Code

FG 20

122814 20

FP001 183

M136450 23

M136740 8

M136986 20

M137075 43

M137164 2

M137361 5

M137820 82

OVER002 925

M137507 150

M137587 250

M137963 400

M138040 125

ST350 13

M135704 13

✓6

Picklist Print

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Work Order ID: 164638

164638

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 8/10/2017

Required Date: 8/22/2017

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

270

Each

1,314.000

4

4

AN3C5A

Bolt

**

12/10/06

Location

Loc Qty

Loc Code

FG

5

M137963

X21

122800

5

FP001

443

M137361

443

OVER002

800

M137710

200

M137963

600

ST350

66

M135442

66

NAS1149C0332R

Purchased

No

270

Each

3,974.000

10

10

NAS1149C0332R

WASHER

**

17/09/06

Location

Loc Qty

Loc Code

FP001

918

M138237

X10

m137951

918

GA

502

m133284

22

m136444

480

ST260a

1946

m137851

1946

ST266

608

m137381

608

DART AEROSPACE LTD		Work Order: 164638
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓		TAPE	
3.500	+/-0.010	3.499	✓		VERN 08	
Ø3.200	+/-0.010	3.199	✓		VERN 08	
Ø3.750	+/-0.010	3.748	✓		VERN 08	
30° x 0.060 chamfer	+/-0.010	0.069 x 30°	✓		VERN 08	
88.93	+/-0.030	88.935	✓		TAPE	

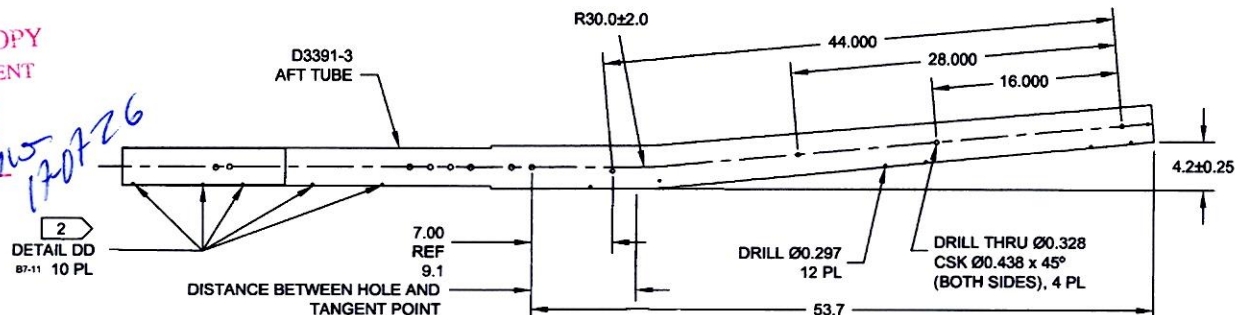
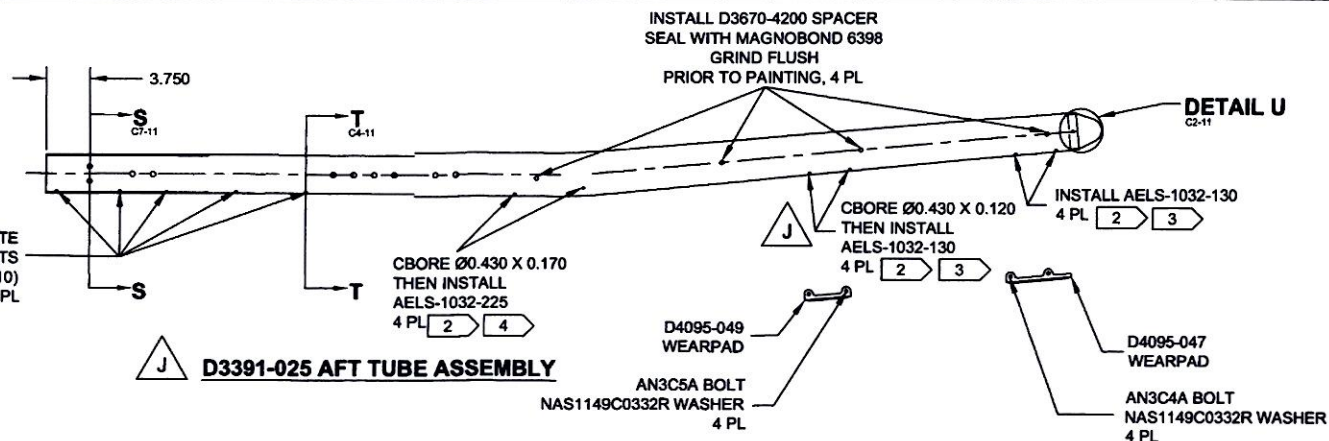
Measured by: PMP	Date: 31-07-2017
Audited by:	Date:

HAAS Section						
1.526	+0.000/-0.030	1.526	✓		MJP-04	vern
7.500	+/-0.010	7.501	✓		---	vern
27.750	+/-0.010	27.750	✓		---	Tape
31.750	+/-0.010	31.750	✓		---	Tape
35.250	+/-0.010	35.250	✓		---	Tape
3.300	+/-0.010	3.307	✓		MJP-04	vern
0.200	+/-0.010	0.210	✓			
3.520	+/-0.010	3.530	✓			
0.687	+0.010/-0.000	0.683	✓			
R0.062	+/-0.010	0.062	✓			
Ø0.484	+0.005/-0.001	0.488	✓			

Measured by: 33	Date: 17/08/16
Audited by: 45	Date: 2017-8-16

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	
M	16.06.23	Dimensions updated per Rev J	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164638 M5 170726



BENDING AND DRILLING DETAIL

D3391-025 AFT TUBE ASSEMBLY PARTS LIST

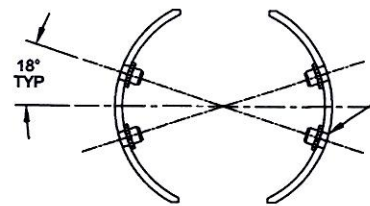
QTY	PART NUMBER	DESCRIPTION
X	D3391-025	AFT TUBE ASSEMBLY
1	D2646	AFT CAP
1	D3391-3	AFT TUBE
4	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE FLOATING
10	NAS1149C0332R	WASHER

NOTES:

- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. C'BORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED. USE NUT PLATE DRILL JIG IF REQUIRED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		AFT TUBE ASSEMBLY	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

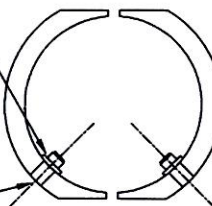


SECTION S-S D6-8.9
SCALE 5X

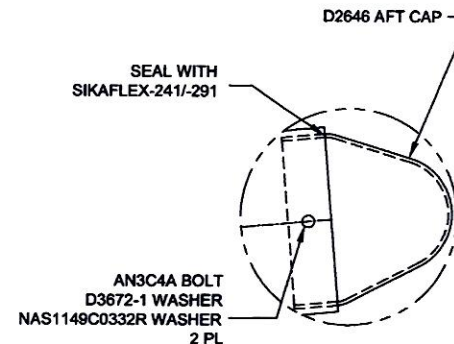
DRILL $\varnothing 0.391$
CBORE $\varnothing 0.516 \times 0.040$ DEEP
INSTALL ALS4-428-165 INSERT
4 PL

USE DT8217 DRILL TEMPLATE
TO LOCATE HOLES AND OPEN
TO $\varnothing 0.375$

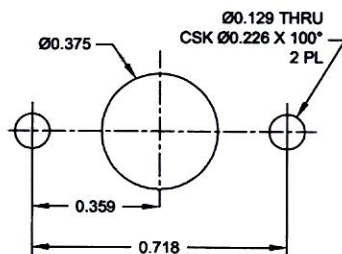
MS21075L5 NUTPLATE
REF



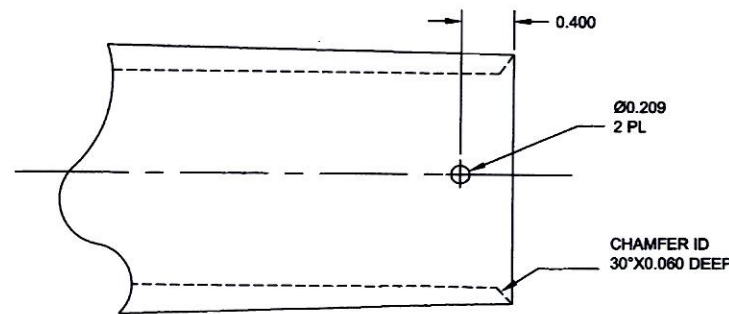
SECTION T-T D6-8.9
SCALE 5X
5 PL J



DETAIL U D1-8.9
SCALE 5X



DRILLING DETAIL DD
SCALE 10X
D7-8.9 1 J



DETAIL EE D1-11
SCALE 2X
J

NOTES:
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	PR	D3391	SHEET 11 OF 11
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	AFT TUBE ASSEMBLY	NTS
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☒</td> <td>Cross tube ☒</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☒	Cross tube ☒	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																	
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Date: 17/8/17		Step #: 100		QTY Effective: 2		MRB (QSI042) Approval DAS 12 17/8/17 9-89																																																																																																																																	
Description Work Order Deviation				Disposition																																																																																																																																			
Tube was cut long, resulting in taper shifting by 1.07" aft. Tap O.D. is therefore over tolerance uniformly. At end, dim $\phi 3.200$ (dwg) is $\phi 3.217$. <i>Re. operator did not cut tube before machining.</i>				Tube is stronger, weight is 20.3 ^{1/2} over nominal. Test fit girt at step 190 to ensure bolts are sufficiently long. <i>Test fit acceptable w/ 11N hardware 17/8/22</i>																																																																																																																																			
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37596**

Purchase Order Date 8/29/2017

PO Print Date 8/29/2017

Page Number 1 of 3

Order From :

VC-ATE001

Ship To : DART AEROSPACE LTD

ATELIER DEBOSELAGE
358 PRINCIPALE
CALUMET, QC J0V 1B0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 819 242 5633

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	164638	D3391-025 TUBE	9/1/2017 Yes 9/1/2017		1.00	\$110.00	\$110.00
Line Total:							\$110.00
2	164788	D3391-025 TUBE	9/1/2017 Yes 9/1/2017		1.00	\$110.00	\$110.00
Line Total:							\$110.00
3	149931	D3391-025 TUBE	9/1/2017 Yes 9/1/2017		1.00	\$110.00	\$110.00

PO Instructions: PRIMER AND PAINT SUPPLIED BY DART

Note:

8/29/2017